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H704-NPC — straight pulling head for Cherry Rivetless NutPlate

Rivetless Nut Plate Pulling Head - Composite Applications.

Specification

Item	Value
Type	Straight pulling head
Maker	Cherry Aerospace
Weight	0.25 lb (0.11 kg)
Tool sheet	TS-H704-()NPC, Rev. B, 21 Oct 15

Part numbers

Pulling head 5 part numbers

Part no.
H704-275NPC
H704-290NPC
H704-305NPC
H704-320NPC
H704-368NPC

What it installs as supplied

Fastener	Diameter	Note
Cherry Rivetless NutPlate (short stem and standard) for composite structures	—	modular system: any size under 5/16" with correct nose piece and insert, selected by installation hole diameter

Riveters

Riveter	Adapter	Note
G704B	—	Cherry riveter
G-800	correct adaptors	Cherry hand riveter; release pressure first

Reconfiguration: nosepiece, jaws and follower

Fastener	Hole	Nosepiece	Jaws	Jaw follower	Note
Rivetless NutPlate, hole dia .275" Min	.275 Min	652-129	652-043	652-116	head H704-275NPC; insert 652-130
Rivetless NutPlate, hole dia .290" Min	.290 Min	652-156	652-043	652-116	head H704-290NPC; insert 652-157
Rivetless NutPlate, hole dia .305" Min	.305 Min	652-159	652-043	652-116	head H704-305NPC; insert 652-160
Rivetless NutPlate, hole dia .320" Min	.320 Min	652-165	652-043	652-116	head H704-320NPC; insert 652-166
Rivetless NutPlate, hole dia .368" Min	.368 Min	652-174	652-043	652-116	head H704-368NPC; insert 652-175

Cherry's Table 1. Change these parts to install the other fasteners.

Parts list

Item	Part number	Description	Qty
1	747-042	Drawbar	1
2	P1442	Compression Spring	1
3	652-116	Jaw Follower	1
4	652-043	Jaw Set	1
5	652-115	Collet	1
6	671A16	Jam Nut	1
7	652-114	Sleeve	1
8	See Table 1	Insert	1
9	See Table 1	Nose Piece	1

Notes

- Use jam nut (item 6) to secure sleeve assembly in position for optimal installation and stem front ejection.
- Select nose piece/insert based on size of hole where the RNP will be installed.
- Table 1: H704-275NPC .275" Min NP 652-129 Insert 652-130; H704-290NPC .290" Min 652-156/652-157; H704-305NPC .305" Min 652-159/652-160; H704-320NPC .320" Min 652-165/652-166; H704-368NPC .368" Min 652-174/652-175.
- Clean nose piece, jaw set and collet every 1,000 installations or on failure; wire brush to clean copper deposited inside jaw set. Lubricate outside of jaw set with Lubriplate or similar light lubricant. Loctite 242 (removable) on nose piece and collet threads.

SOURCES · Cherry Aerospace, Tool Sheet TS-H704-NPC, Rev. B, 21 Oct 15

SCAN · OPEN THIS DATA SHEET
theaviationpoint.com/parts/tools/h704-npc/

Reference data. The aircraft manufacturer's documentation (SRM / IPC) takes precedence.